








Work Order ID 51991




September 11, 2009 9:04:17 AM

Page 1

Item ID:	D3883-2	Accept		Setup	Start	
Revision ID:	B					
Item Name:	Saddle, Outboard RH				Stop	
Start Date:	09/14/2009	Start Qty: 4.00		Cust Item ID:		
Required Date:	09/23/2009	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>mf</u>	Date: <u>09-09-11</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3883	B								

100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	<p>Memo</p> <p>Program Batch No. <u>88</u></p> <p>Double check by: <u>88</u></p> <p>1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets</p> <p>2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets</p> <p>3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets</p>								
				<u>88 09/09/19</u>		<u>2</u>	<u>0</u>		
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								
				<u>88 09/09/19</u>		<u>2</u>	<u>0</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/09/18	100	One saddle have a deviation on one side of the bore 1.265. The wall is too thin by .015" under minimum tolerance.		NO replace, NO Material.	SF 09/09/18			
		R.C. ??? operator on other shift		Wrong w/o	SF 09/09/20			

NOTE: Date & initial all entries

Work Order ID 51991

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Item ID: D3883-2

Accept



Setup Start



Revision ID: B

Item Name: Saddle, Outboard RH

Stop



Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

DJP
09/09/21

2

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

MO 09/09/21

(X2)

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

11:50
START TIME:
OVEN TEMPERATURE: 320 °F
FINISH TIME: 12:20

M112260

(2X)

Powder Coating

M-L 09/09/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51991

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Page 3

Item ID: D3883-2

Accept



Setup Start



Revision ID: B

Item Name: Saddle, Outboard RH

Stop



Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09/15/21 (L)

160

Identify as per dwg & Stock Location: 429

0.00



Packaging

Memo

0.00

Packaging

09/16/21 (L)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/22
MF
09-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 11, 2009 9:04:16 AM

Page 1

Work Order ID: 51991



Parent Item: D3883-2RevB



Parent Item Name: Saddle, Outboard RH

Start Date: 09/14/2009

Required Date: 09/23/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-015RevB		Manufactured	No			100	Each	0.0000	4.0000			



Saddle Billet

Batch B 47459

mk 09/16/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51991
Description: <i>Saddle, Out Board RH</i>		Part Number: D3883-2
Inspection Dwg: D3883	Rev: B	Page 1 of 2

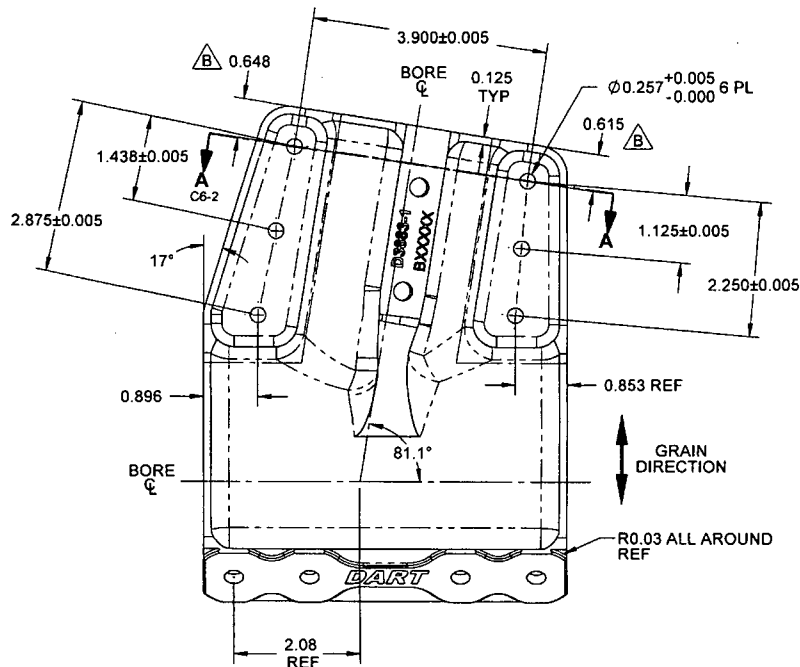
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

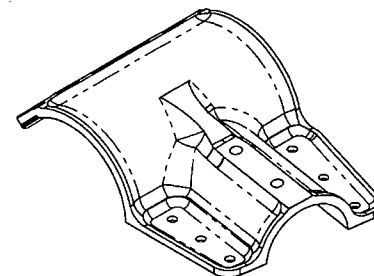
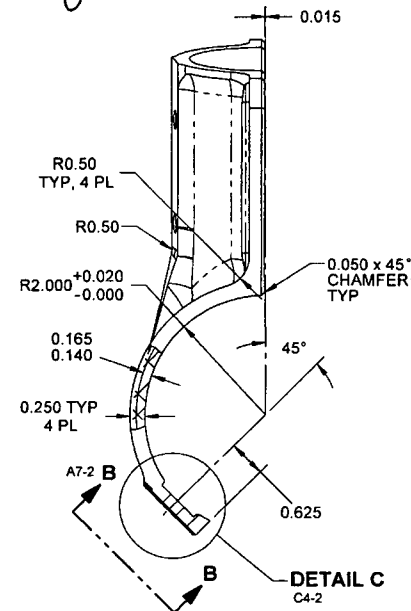
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	±.005	3.896	✓			
2.250	"	2.250	✓			
1.125	"	1.127	✓			
1.438	"	1.437	✓			
2.375	"	2.374	✓			
.648	±.010	.643	✓			
.615	±.010	.613	✓			
.250	"	.248	✓			
.165 1.25	✓	.152	✓			
2.000	+ .020 - .020	2.010	✓			
.125	±.010	.126	✓			
.250	±.010	.251	✓			
.110 1.40	✓	.135	✓			
2.855	±.030	2.872	✓			
.750	±.030	.775	✓			
1.265	+ .020 - .020	1.282	✓			
.313	+ .005 - .000	.316	✓			
1.250	±.005	1.252	✓			
2.500	"	2.501	✓			
1.250	"	1.252	✓			
.500	±.010	.496	✓			
.316	+ .005 - .000	.308	✓			
1.000	±.010	.998	✓			

Measured by: <i>SS</i>	Audited by: <i>DJP</i>	Prototype Approval:	N/A
Date: 09/09/20	Date: 09/09/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



#51991
mf
09-09-11



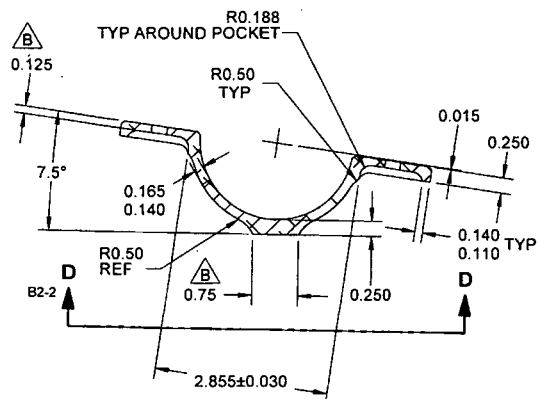
D3883-1 SADDLE, OUTBOARD LH (SHOWN)
D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

RELEASED
07/07/15

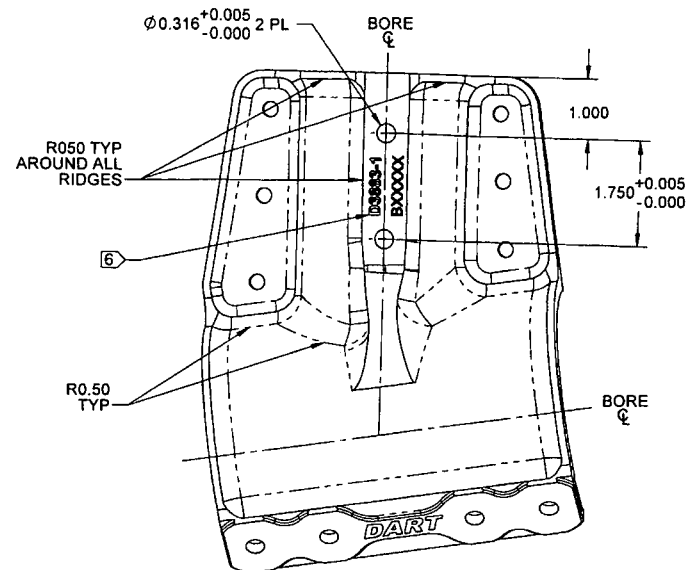
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

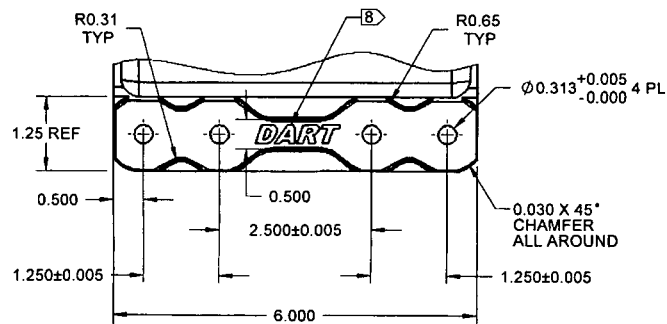
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3883	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD SADDLE	NTS
DATE	09.06.30	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



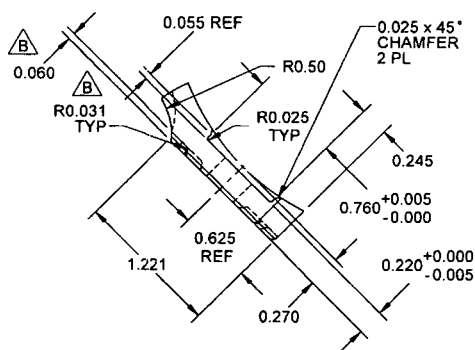
SECTION A-A C7-1



VIEW D-D C7-2



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, VA	
CHECKED	RF	DRAWING NO. D3883	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 2
APPROVED		OUTBOARD SADDLE	SCALE
DE APPR.			NTS
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RELEASED
09/07/15

51991